



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5162-041
Job Sheet 199991



Part No: D5162-041

Job Qty: 1 pcs

Part Name: Seat Structure Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/5/19

Job Tracking No:

Due Date: 9/26/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D3016 REV (DEO) A1, D5162 REV A, D5189 REV A, D3017 REV C IPP REV:A 14.11.05 NEW ISSUE
DD VERF:JLM IPP REV:B 15-02-06 AS PER DWG REV:A DD VERF:JLMIPP REV:C 16.08.31 ADD D3016
PARTS DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Large Fab - Welded Assy-1	1 pcs		9/26/19	24.00	4.63	Large Fab - 1		E
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
140	QC 5	1 pcs		9/26/19	0.00	0.00	QC 5 - 10		OCT 02 2019
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30	DAS	81
							QC 5 - 40	9-89	
							QC 5 - 61		
							QC 5 - 81		



Container No: S219161



Part: D5162 - 041

Job No: 199991

Serial No/Batch: S219161

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 10/02/19

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

165 Large Fab - Welded Assy-2-B4B	1 pcs	9/26/19	0.00 4.63	Large Fab - 1 - B4B	
				Large Fab - 10 - B4B	
				Large Fab - 2 - B4B	
				Large Fab - 3 - B4B	
				Large Fab - 4 - B4B	
				Large Fab - 5 - B4B	
				Large Fab - 6 - B4B	
				Large Fab - 7 - B4B	
				Large Fab - 8 - B4B	
				Large Fab - 9 - B4B	
				Large Fab - 11 - B4B (Various)	
170 QC 9	1 pcs	9/26/19	0.00 0.00	QC 9 - 10	
				QC 9 - 18	
				QC 9 - 24	CPL
				QC 9 - 43	
				QC 9 - 50	
				QC 9 - 9	
175 QC 5	1 pcs	9/26/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	CPL
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	QC 5 - 68
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
180 Handfinish - 1-1 Chemical-B4B	1 pcs	9/26/19	0.00 0.47	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	OCT 03 2019
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	

190 QC 7	1 pcs	9/26/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	DAS 58 OCT 03 2019 9-52
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	
				QC 7 - 61	
				QC 7 - 81	
200 Small Fab - 2 - B4B	1 pcs	9/26/19	0.00 1.00	Small Fab - 1 - B4B	DAS 58 OCT 03 2019 9-52
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
				Small Fab - 8 - B4B	
210 QC 5	1 pcs	9/26/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	DAS 81 OCT 03 2019 9-89
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
220 Powdercoat - 3 Grey Sand - B4B	1 pcs	9/26/19	0.00 0.29	Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	

9/5/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

BL 19-10-7

				Powdercoat - 3 - B4B	
				Powdercoat - 4 - B4B	
230 QC 3	1 pcs	9/26/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
240 Small Fab - 3 - B4B	1 pcs	9/26/19	0.00 1.00	Small Fab - 1 - B4B	
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
				Small Fab - 8 - B4B	
250 QC 5	1 pcs	9/26/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
260 Packaging 3-1 - Stock - B4B	1 pcs	9/26/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	

DAS
58
9-89
OCT 07 2019DAS
58
9-89
OCT 07 2019DAS
40
9-89
OCT 07 2019DAS
58
OCT 08 2019

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				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
270 QC 21 - SA				QC 21 - SA - 21	DAS
1				QC 21 - SA - 70	21
pcs				QC 21 - SA - 53	9-89
9/26/19				OCT 08 2019	
0.00 0.00					

Part Op 110 - (Weld per dwg A/R 4130 rod Batch: M127925), FABRICATE D3017-041 AS PER DWG: USE DT8598 FOR
 Descriptions: BENDING D3017-1/-3 TUBE. USE DT8621 FOR DRILLING (#30 DRILL) BACK FRAME. ***DO NOT OPEN HOLES IT
 WILL BE DONE AT FUTHER STEP*** USE DT8622 FOR DRILLING (#30 DRILL) D3017-5. ***DO NOT OPEN HOLES IT
 WILL BE DONE AT FUTHER STEP*** USE DT8598 JIG FOR WELDING TUBES, LUGS AND ONE END CAP, OTHER
 END CAP WILL BE WELDED AFTER OPENING HOLES.
 140 - (QC5- Inspect part completeness to step on W/O)
 165 - (Weld per dwg A/R 4130 rod Batch: M127925), 1- BOLT SEAT FRAME TO ASSEMBLY PLATE DT8624. 2-
 TRANSFER DRILL D5189-041 TO D3016-041 AS PER DWG USING #30 DRILL AND CLECO THEN DRILL TO FINISH
 SIZE. 3- TRANSFER DRILL SEAT PAN TO D5189-041 AND 3016-041. 4- TRASFER DRILL SEAT AND D3016-041 TO
 D3017-041 USING DT DT10132 AND USING TOOL TO ACHIEVE DESIRED ANGLE ON BACK REST. ARMREST: 1-
 ASSEMBLE AND TRANSFER DRILL D5189-043 TO D3017-041. OPEN HOLES TO FINISH SIZE AS PER DWG SEAT
 BRACE: 1- USE DT10132 AND DT10133 TO TRANSFER DRILL HOLES IN SEAT PAN AND SEAT BRACE.
 170 - (QC9- Inspect visual per QSI004- Fusion Welds)
 175 - (QC5- Inspect part completeness to step on W/O)
 180 - (Chemical Conversion Coat per QSI005 4.1), CHEMICAL CONVERSION SEAT PANEL D3022-1 AND BACK
 PANEL D3023-1 AS PER DWG
 190 - (QC7-Inspect Chemical Conversion Coat)
 200 - (TO FABRICATE D5162-051) ASSEMBLE D3023-1 PANEL TO D3017-041 BACK FRAME AS PER DWG D5162-
 051
 210 - (QC5- Inspect part completeness to step on W/O)
 220 - (Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3), POWDER COAT ALL INDIVIDUAL PARTS START TIME:
8:20 OVEN TEMPERATURE: 600 FINISH TIME: 9:10 M127925
 230 - (QC3- Inspect Part Finish)
 240 - ASSEMBLE AS PER DWG
 250 - (QC5- Inspect part completeness to step on W/O)
 260 - (Identify as per dwg & Stock Location: _____)
 270 - (QC21- Final Inspection - Work Order Release)

012054

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2199-31	Strut Details	1 pcs (1 ea)	110-Large Fab - Welded Assy-1	5152219
D3016-1	Tube	2 pcs (2 ea)	110-Large Fab - Welded Assy-1	5203063
D3016-11	Saddle	2 pcs (2 ea)	110-Large Fab - Welded Assy-1	5202901 -
D3016-3	Tube	4 pcs (4 ea)	110-Large Fab - Welded Assy-1	5149863
D3016-5	Tube	2 pcs (2 ea)	110-Large Fab - Welded Assy-1	5203373
D3016-7	Tube	4 pcs (4 ea)	110-Large Fab - Welded Assy-1	5204180
D3016-9	Saddle	2 pcs (2 ea)	110-Large Fab - Welded Assy-1	5202909 -
D5159-041	Seat Back Brace Assembly	1 pcs (1 ea)	110-Large Fab - Welded Assy-1	5215776
D5159-043	Seat Back Brace Assembly	1 pcs (1 ea)	110-Large Fab - Welded Assy-1	5215503
D5159-045	Seat Rib Assembly	1 pcs (1 ea)	110-Large Fab - Welded Assy-1	5209373
M4130NT0.750W.049	4130 Round Tube .750 X.049W	13.8000 ft (13.8 ea)	110-Large Fab - Welded Assy-1	5155281
M4130NT0.750W.083	4130 Round Tube .750 X.083W	2.5000 ft (2.5 ea)	110-Large Fab - Welded Assy-1	5155282
D3016-13	Bracket	2 pcs (2 ea)	110-Large Fab - Welded Assy-1	5103110
D3016-15	Gusset	2 pcs (2 ea)	110-Large Fab - Welded Assy-1	5103100
D3016-17	Gusset	2 pcs (2 ea)	110-Large Fab - Welded Assy-1	5103200
D3017-11	Cap	4 pcs (4 ea)	110-Large Fab - Welded Assy-1	5214908
D3017-7	Lug	3 pcs (3 ea)	110-Large Fab - Welded Assy-1	5204532
D3020-1	Fitting	4 pcs (4 ea)	110-Large Fab - Welded Assy-1	5203069
D3022-1	Seat Pan	1 pcs (1 ea)	110-Large Fab - Welded Assy-1	5206485
D3023-1	Back Panel	1 pcs (1 ea)	110-Large Fab - Welded Assy-1	5206483
D4667-041	Armrest Stud Assembly	1 pcs (1 ea)	110-Large Fab - Welded Assy-1	5162717
D5190-1	Armrest Fitting	1 pcs (1 ea)	110-Large Fab - Welded Assy-1	5190326
D5190-3	Weld Pin	1 pcs (1 ea)	110-Large Fab - Welded Assy-1	5146053
MS20600-AD4W2	Rivet	40 Ea (40 ea)	200-Small Fab - 2 - B4B	5203371 X20 S
MS20600-AD4W3	Cherry Rivet	6 Ea (6 ea)	200-Small Fab - 2 - B4B	5196554
AN3-12A	Bolt	3 Ea (3 ea)	240-Small Fab - 3 - B4B	5116926
AN4-14A	Bolt	2 Ea (2 ea)	240-Small Fab - 3 - B4B	5212407
AN4-4A	Bolt	1 Ea (1 ea)	240-Small Fab - 3 - B4B	5193116
AN4-6A	Bolt	1 Ea (1 ea)	240-Small Fab - 3 - B4B	5199877
AN970-4	Washer	1 Ea (1 ea)	240-Small Fab - 3 - B4B	5200671
D3024-1	Spacer	3 pcs (3 ea)	240-Small Fab - 3 - B4B	5162857
D3031-1	Loop	2 pcs (2 ea)	240-Small Fab - 3 - B4B	5205021
MS20600-AD4W4	Rivet	4 Ea (4 ea)	240-Small Fab - 3 - B4B	5071525
MS20600-AD4W5	Blind Rivet	8 Ea (8 ea)	240-Small Fab - 3 - B4B	PM 131610
MS21042L3	Nut	17 Ea (17 ea)	240-Small Fab - 3 - B4B	5211533
MS21042L4	Nut	8 Ea (8 ea)	240-Small Fab - 3 - B4B	5214967
MS24693-S272	Screw	4 Ea (4 ea)	240-Small Fab - 3 - B4B	5198111
MS27039-1-17	Screw (601.1954)	1 Ea (1 ea)	240-Small Fab - 3 - B4B	PM 127831-4
MS27039-1-18	Screw	3 Ea (3 ea)	240-Small Fab - 3 - B4B	5124326-1
MS27039-1-19	Screw	4 Ea (4 ea)	240-Small Fab - 3 - B4B	5210380
MS27039-1-20	Screw	2 Ea (2 ea)	240-Small Fab - 3 - B4B	5182772
MS27039-4-20	Screw	4 Ea (4 ea)	240-Small Fab - 3 - B4B	5180006
MS27039-4-21	Screw	2 Ea (2 ea)	240-Small Fab - 3 - B4B	5188573
NAS1149D0332J	Washer	30 Ea (30 ea)	240-Small Fab - 3 - B4B	5209100 X20
NAS1149D0432J	Washer	17 Ea (17 ea)	240-Small Fab - 3 - B4B	5211211
NAS43DD4-16FC	Spacer	2 Ea (2 ea)	240-Small Fab - 3 - B4B	5156480

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Large Fab - Welded Assy-1	D2199-31	1	3	0
	D3016-1	2	14	0
	D3016-11	2	4	0
	D3016-13	2	2	0
	D3016-15	2	12	0
	D3016-17	2	24	0
	D3016-3	4	5	0
	D3016-5	2	4	0
	D3016-7	4	4	0
	D3016-9	2	4	0
	D3017-11	4	1	0
	D3017-7	3	19	0
	D3020-1	4	12	0
	D3022-1	1	1	0
	D3023-1	1	1	0
	D4667-041	1	15	0
	D5159-041	1	0	0
	D5159-043	1	0	0
	D5159-045	1	2	0
	D5190-1	1	9	0
	D5190-3	1	5	0
	M4130NT0.750W.049	14	71	0
	M4130NT0.750W.083	3	39	0
	MS20600-AD4W2	40	105	0
	MS20600-AD4W3	6	434	0
	AN3-12A	3	151	0
	AN4-14A	2	127	0
	AN4-4A	1	51	0
	AN4-6A	1	385	0
	AN970-4	1	75	0
	D3024-1	3	28	0
	D3031-1	2	14	0
	MS20600-AD4W4	4	1,477	0
	MS20600-AD4W5	8	59	0
	MS21042L3	17	2,119	0
	MS21042L4	8	1,922	0
	MS24693-S272	4	144	0
	MS27039-1-17	1	30	0
	MS27039-1-18	3	1,105	0
	MS27039-1-19	4	231	0
	MS27039-1-20	2	62	0
	MS27039-4-20	4	55	0
	MS27039-4-21	2	47	0
	NAS1149D0332J	30	2,202	0
	NAS1149D0432J	17	906	0
	NAS43DD4-16FC	2	47	0
200-Small Fab - 2 - B4B				
240-Small Fab - 3 - B4B				

Part Specifications

Specifications could not be found.

Plex 9/5/19 1:01 PM Dart.lajeunesse.marie



Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

DISPOSITION		DEPARTMENT/PROCESS			
Job: _____	Rework ☐	Skid-tube ☐	Cross tube ☐	Eng. (Non-AW) ☐	Engineering ☐
Part No. _____	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Water Jet ☐
	Use-as-is ☐	Large Fab ☐	Finishing ☐	Rec/Store/Packaging ☐	Supplier ☐
					Quality ☐
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QS1042) _____	
Description Work Order Deviation		Disposition			
Root Cause		FAULT CATEGORY			
Operator ☐	Pressure/Forced ☐	Contamination ☐	Power Loss/Surge ☐	Positioned Wrong ☐	
Manufacturing Process ☐	Bending ☐	Misaligned/off center ☐	Folio/Program ☐	Outside Tolerance ☐	
Equip/Tooling ☐	Crushing ☐	BOM/Route ☐	Grain Direction ☐	Drawing ☐	
Handling/Preservation ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Finish ☐	
Material ☐	Crimp/Kink/Ripple/Wave/Twist ☐	Incomplete/Unclear Instructions ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	
Product Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Out of Sequence ☐	Misread ☐	
Process Improvement ☐	Mislabeled ☐	Fit/Function ☐	Off-set/Set-up ☐		
Human Factors ☐	Other/Details: _____				